

Work Order ID 117836

May-16-14 1:34:07 PM

Report
1178.36

Page 1

Item ID: D206-817-011
Revision ID: *U/R* *UP 14/5/20*
Item Name: Screw-In Windshield Modification

Accept

N900040100

Setup Start *NS1*
Stop *NS2*

Start Date: 5/26/14 Start Qty: 2.00 *2*
Required Date: 5/26/14 Req'd Qty: 2.00 *2*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *W* Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI9659	A
DSI9687	A
IIN-D206-817	D

100 Document Control 0.00
100 DOCUMENT CONTROL

DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D206-817-011 CHG005

JUN 02 2014

DAS
06
9-89

2

MUS 14-05-20
(2)

110 Pick Kit 0.00

110 Packaging Memo 0.00
Packaging

2

DAS
33 14-05-27
9-89

see w/o 118889

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Page 2

Item ID: D206-817-011
Revision ID: U/R
Item Name: Screw-In Windshield Modification

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 5/26/14 Start Qty: 2.00 ***2***
Required Date: 5/26/14 Req'd Qty: 2.00 ***2***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00			DAS 06 29	2			
Quality Control									
130		0.00							
130									
Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-817-011 Location: <u>OS7</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

JUN 02 2014

JUN 02 2014

DAS
06
9-89

DAS
28
9-89

MLJ 140602

MLJ 140602

Picklist Print

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Work Order ID: 117836

117836

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.02.14 NEW ISSUE DD VERF: IPP REV:B
12.05.09 AS PER IIN REV.C DD VERF:EC IPP REV:C 12.06.12
ECN 12-602 DD VERF:EC IPP REV:D 13.04.23 as per IIN
dwg rev.D DD verf:JLM IPP REV:E 13.06.26 as per
CHG004/DSI9659 DD VERF:JFS IPP REV:F 14.03.24 AS PER DSI 9687
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-1 *D4541-1* Bracket		Manufactured	No			110	Each	5.0000	1	2			
									**			DAS 33 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST531				5					
					115540			5					
D4541-2 *D4541-2* Bracket		Manufactured	No			110	Each	15.0000	1	2			
									**			DAS 33 9-89	DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST531				10					
					116108			10					
				ST595				5					
					115358			5					
D4542-1 *D4542-1* Retainer, Inner, LH		Manufactured	No			110	Each	1.0000	1	2			
									**			DAS 33 9-89	DAS 14-05-27
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				prelim				1					
					115282			1					
												DAS 28 9-89	DAS 28 9-89

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Work Order ID: 117836

117836

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 2.00

Required Qty: 2.00

2 D4542-2

Manufactured No

110 Each

1.0000

2

DAS

D4542-2

Retainer, Inner, RH

DAS
06
9-89

Location

Loc Qty

Loc Code

prelim

1

115283

1

110 Each

12.0000

2

DAS

28

9-89

116101 DAS

33

9-89

2 D4541-3

Manufactured No

110 Each

12.0000

2

D4541-3

Bracket

DAS
06
9-89

Location

Loc Qty

Loc Code

prelim

8

115218

8

st530

4

109382

4

110 Each

13.0000

2

DAS

28

9-89

DAS

33

9-89

115218

2 D4541-4

Manufactured No

110 Each

13.0000

2

D4541-4

Bracket, RH

DAS
06
9-89

Location

Loc Qty

Loc Code

prelim

10

115295

10

st530

3

109484

3

110 Each

1.0000

2

DAS

28

9-89

DAS

33

9-89

109484

2 D4541-5

Manufactured No

110 Each

1.0000

2

D4541-5

Bracket, LH

DAS
06
9-89

Location

Loc Qty

Loc Code

prelim

1

115219

1

DAS

28

9-89

DAS

33

9-89

115920

14-05-27

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Shop Packet Print

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Picklist Print

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Work Order ID: 117836

117836

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 2.00

Required Qty: 2.00

2 ***D4541-6***
Bracket, RH

DAS
06
9-89

Manufactured No

110 Each

3.0000

**

2

DAS
33
9-89

DAS
28
9-89

116674

Location

Loc Qty

Loc Code

ST525

3

115293

3

110 Each

12.0000

**

2

DAS
33
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

prelim

2

115220

2

ST525

10

116104

10

110 Each

2.0000

**

2

DAS
33
9-89

DAS
28
9-89

116104

Location

Loc Qty

Loc Code

prelim

2

115294

2

110 Each

9.0000

**

4

DAS
33
9-89

DAS
28
9-89

115294

Location

Loc Qty

Loc Code

ST532

9

110159

8

111485

1

110159

2 ***D4541-8***
Bracket

DAS
06
9-89

Manufactured No

110 Each

2.0000

**

2

DAS
33
9-89

DAS
28
9-89

2 ***D4542-3***
Retainer, Inner

DAS
06
9-89

Manufactured No

110 Each

9.0000

**

4

DAS
33
9-89

DAS
28
9-89

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Work Order ID: 117836

117836

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 2.00

Required Qty: 2.00

D4542-5	Manufactured	No	110	Each	6.0000	2	4			DAS 28 9-89
D4542-5										
Retainer, Inner										
DAS 06 9-89										
D4542-7	Manufactured	No	110	Each	12.0000	2	4			DAS 28 9-89
D4542-7										
Retainer, Inner										
DAS 06 9-89										
D4543-1	Manufactured	No	110	Each	4.0000	1	2			DAS 28 9-89
D4543-1										
Retainer, LH Outer (Lower)										
DAS 06 9-89										
D4543-2	Manufactured	No	110	Each	3.0000	1	2			DAS 28 9-89
D4543-2										
Retainer, Outer, RH										
DAS 06 9-89										

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117836

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 2.00

Required Qty: 2.00

D4543-3 Manufactured No

110 Each

10.0000

2

DAS
33
9-89

DAS
28
9-89

D4543-3
Retainer, Outer, LH

DAS
06
9-89
D4543-4

Manufactured No

110 Each

11.0000

2

DAS
33
9-89

DAS
28
9-89

D4543-4
Retainer, RH Outer (Sloe)

DAS
06
9-89

Location

Loc Qty

Loc Code

ST528

10

116058

10

116058

D4543-5

Manufactured No

110 Each

11.0000

2

DAS
33
9-89

DAS
28
9-89

D4543-5
Retainer, Outer, LH

DAS
06
9-89

Location

Loc Qty

Loc Code

st529

11

109040

11

109040

D4543-6

Manufactured No

110 Each

12.0000

2

DAS
33
9-89

14-05-27

D4543-6
Retainer, Outer, RH

DAS
06
9-89

Location

Loc Qty

Loc Code

st529

12

108205

2

115993

10

115993

DAS
28
9-89

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Work Order ID: 117836

117836

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 2.00

Required Qty: 2.00

D4544-1 Manufactured No

110 Each

4.0000

1 2

DAS
33
9-89

DAS
28
9-89

D4544-1
Retainer Center

DAS
06
9-89

Location

Loc Qty

Loc Code

st530

4

108026

4

6.0000

1 2

DAS
33
9-89

DAS
28
9-89

D4594-1 Manufactured No

110 Each

D4594-1
Plate

DAS
06
9-89

Location

Loc Qty

Loc Code

prelim

6

115222

6

0.0000

2 4

DAS
28
9-89

D4595-150-13 Manufactured No

110 Each

D4595-150-13
Sealant Tape (13' Long)

DAS
06
9-89

119831

AN525-10R7 Purchased No

110 Each

1,465.000

195 190

DAS
33
9-89

14-05-20

AN525-10R7
SCREW

DAS
06
9-89

Location

Loc Qty

Loc Code

ST344

2

m127447

2

ST505

1463

m127815

713

m128429

750

DAS
28
9-89

127815

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Work Order ID: 117836

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

117836

D206-817-011

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-4

Purchased

No

110

Each

7,737.000

190

380

DAS

33

9-89

DAS

28

9-89

MS20426AD3-4

RIVET

DAS

06

9-89

Location

Loc Qty

Loc Code

MF4

309

125578

309

ST334

3180

m127432

3180

ST509

4248

125578

4248

831.0000

43

86

DAS

33

9-89

DAS

28

9-89

MS21059L08

Purchased

No

110

Each

MS21059L08

DAS

06

9-89

Location

Loc Qty

Loc Code

ST508

831

123185

1

125654

830

835.0000

93

186

DAS

33

9-89

14-05-20

MS21059L3K

Purchased

No

110

Each

MS21059L3K

Nutplate

DAS

06

9-89

Location

Loc Qty

Loc Code

GA

179

m127635

179

ST316

656

m127703

156

m129198

500

140x 127703
46x 129198

DAS

28

9-89

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Work Order ID: 117836

117836

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 2.00

Required Qty: 2.00

MS21061L08

Purchased

No

110

Each

150.0000

~~10~~

20

DAS

DAS

33

28

9-89

9-89

MS21061L08

Nutplate

DAS

06

MS21075L08

9-89

Purchased

No

110

Each

383.0000

~~5~~

2

DAS

DAS

28

28

9-89

9-89

MS21075L08

ANCHOR NUT

DAS

06

9-89

Location

Loc Qty

Loc Code

ST317

150

m128635

150

128635

Location

Loc Qty

Loc Code

ST318

383

M126145

33

M128635

200

M128813

150

126145

MS27039-08-10

Purchased

No

110

Each

2,046.000

~~42~~

84

DAS

14-05-20

28

MS27039-08-10

Screw

DAS

06

9-89

Location

Loc Qty

Loc Code

Mezz

6

5865

6

ST307

2040

123265

47

m127430

21

m128799

1972

128799

DAS

28

9-89

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Work Order ID: 117836

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

117836

D206-817-011

Start Date: 5/26/14

Required Date: 5/26/14

Start Qty: 2.00

Required Qty: 2.00

NAS1149DN832J

Purchased

No

110

Each

2,728.000

42

84

DAS

33

9-89

DAS

28

9-89

NAS1149DN832J

Washer

DAS
06
9-89

Location

Loc Qty

Loc Code

MF4

736

M127255

736

ST293

1832

M128948

832

M128429

1000

st510

145

124555

145

ST510a

15

M126319

15

MS21061L3K

Purchased

No

110

Each

46.0000

2

4

DAS

33

9-89

1405-20

MS21061L3K

NUT PLATE

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

4

125268

4

ST317

42

123603

42

DAS

28

9-89

123603

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DAS
06
9-89

DART AEROSPACE LTD.

REFERENCE ONLY

IIN-D206-817

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4.0 WEIGHT AND BALANCE

The weight and balance for the D206-817-011 kit is as follows. These are net weights and include the parts removed.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D206-817-011	2.8 lb	40 in	112 in-lb
Screw-In Windshield Modification Kit	1.3 kg	1.0 m	1.3 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-3	BRACKET, LH
1	D4541-4	BRACKET, RH
1	D4541-5	BRACKET, LH
1	D4541-6	BRACKET, RH
1	D4541-7	BRACKET, LH
1	D4541-8	BRACKET, RH
2	D4542-3	RETAINER, INNER
2	D4542-5	RETAINER, INNER
2	D4542-7	RETAINER, INNER
1	D4543-1	RETAINER, LH OUTER (LOWER)
1	D4543-2	RETAINER, RH OUTER (LOWER)
1	D4543-3	RETAINER, LH OUTER (SIDE)
1	D4543-4	RETAINER, RH OUTER (SIDE)
1	D4543-5	RETAINER, LH OUTER (SIDE)
1	D4543-6	RETAINER, RH OUTER (SIDE)
1	D4544-1	RETAINER, CENTER
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
1	D4594-1	PLATE
1	D4595-150-25	SEALANT TAPE (25' LONG)
195	AN525-10R7	SCREW
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
10	MS21061L08	NUTPLATE
1	MS21075L08	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER (OR AN960JD8)

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Revision: D

Date: 13.04.15

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
& INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV. 2

REF. TCCA STC SH12-3
REF. FAA STC SR03091NY
REF. EASA STC 10039042

1.0 PURPOSE

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO FACILITATE INSTALLATION OF THE RETAINERS ON THE LOWER PORTION OF THE WINDSHIELD, FOR D206-817-011 KITS AT CHG 005 OR LATER, BY REPLACING THE RIGID D4545-041/-042 RETAINER ASSEMBLIES WITH SEPARATE BRACKETS AND RETAINERS THAT ARE ASSEMBLED BY THE INSTALLER AND ALLOW FOR EASIER ADJUSTMENT.

2.0 PARTS LIST

(IS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-1	BRACKET
1	D4541-2	BRACKET
1	D4542-1	RETAINER
1	D4542-2	RETAINER
190	MS20426AD3-4	RIVET
43	MS21059L08	NUTPLATE
93	MS21059L3K	NUTPLATE
2	MS21061L3K	NUTPLATE
42	MS27039-0810	SCREW
42	NAS1149DN832J	WASHER

(ADDED)




(WAS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.18
CERT. NO.: SH12-3
ISSUE NO.: 1

A	NEW ISSUE	AJS	14.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER UPGRADE	NTS
DATE	14.03.18	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2
OR LATER APPROVED REVISION

REF. TCCA STC: SH12-3
REF. FAA STC: SR03091NY
REF. EASA STC: 10039042

1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

3.0 INSTALLATION

INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.

4.0 WEIGHT AND BALANCE







THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 13.06.20
CERT. NO.: SH12-3
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